

Work Order ID 132251-2

Tuesday, May 05, 2015 9:07:15 AM

SP2 IT-2

132251

RUSH ship Thursday

Page 1

Item ID: D3403-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bushing

Start Date: 5/5/2015 Start Qty: 40.00

40 32

Cust Item ID:

Required Date: 5/22/2015 Req'd Qty: 40.00

40 32

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 5-5-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3403	D								
100	Hardinge CNC LATHE SMALL	0.00				32	Ø	DAS 37 9-89	15.05.07
100									
Hardinge	Memo	0.07							
Hardinge CNC Lathe Small	1- Turn as per Folio FA556 & Dwg D3403 Folio Rev: 4A Dwg Rev: _____ 2-Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				32	Ø	DAS 37 9-89	15.05.07
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00				32	Ø	DAS 08 9-89	
120									
QC	Memo	0.01							
Quality Control									

B. 15/05/07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Tuesday, May 05, 2015 9:07:15 AM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

40

Cust Item ID:

40

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Operation Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: S1057

0.00

130

Packaging

Memo

0.07

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.01

Quality Control

MAY 11 2015

MCQ

MAY 12 2015

MCS MAY 12 2015

DQA: _____ Date: _____

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Picklist Print

Tuesday, May 05, 2015 9:07:14 AM

Work Order ID: 132251

132251

Parent Item: D3403-1

D3403-1

Parent Item Name: Bushing

Start Date: 5/5/2015

Required Date: 5/22/2015

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A05.08.31New issueKJ/JLM
IPP Rev:B 06-03-07 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	86.3500	0.217	10		DAS 37 9-29	
M303R0 750									**		15.05.07		
303 Round Bar 0.750													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT028	86.35	
m131891	49.35	
m131999	37	

7.5 SL

DQA: _____ Date: _____



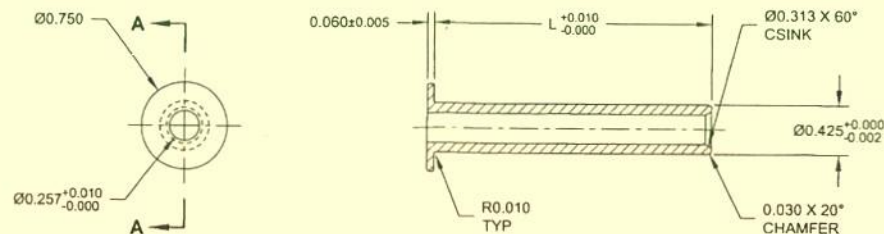
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						



SECTION A-A

D3403-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3403-1	2.416	0.07
D3403-3	2.165	0.06
D3403-5	2.440	0.07



WV
#132251

RELEASED
2011-10-31
WV

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
PER ASTM A582
REF. DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

D	FOR -5, 2.440 WAS 2.500 (PER PAR 11-125)	XDF	11.10.28
C	REFORMAT TO CURRENT STD PER QSI 043; ADDED D3403-5, TOL WAS +0.005/-0.000. REASON: PAR#10-029	MB	10.04.21
B	ADD COUNTERSINK	PH	06.01.23
A	NEW ISSUE	PH	05.03.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. D
D3403 SHEET 1 OF 1
TITLE SCALE
BUSHING NTS

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